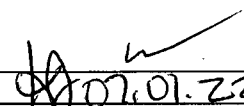
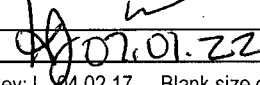


Date: Monday, 1/22/2007 7:44:20 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BEARPAW KIT (19"X24")
<b>Job Number</b> : 30340	
<b>Estimate Number</b> : 10323	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D206559013
<b>This Issue</b> : 1/22/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2432 REV F3
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : F3
<b>Previous Run</b> : 28818	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 2/12/2007 <b>Qty:</b> 16 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est Rev:J 04.02.17 Blank size changed KJ/JLM Est Rev:K 07-01-02 Was K10008 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy bluefile:

D206-559-013

and create labels per PPP D206-559-013

CHG0015 Bag Bluefiles separately)

KS 07.01.24

2.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



**Comment:** Qty.: 6.8250 sf(s)/Unit Total : 109.2000 sf(s)  
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5  
 Material: Black UHMW 1"  
 (MUHMWB10)  
 Batch: M 103.3/5

J.F. 07/02/12

(16)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

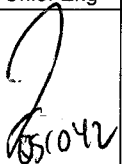
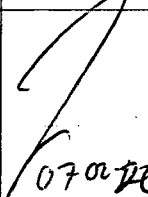

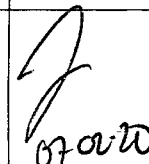
J.F. 07/02/12

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 07/02/20

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/02/17	3.0	Part zero was off and The pieces was off center The machine zero add move	 051042	Scrap, destroyed, and replaces	D.F. 07/02/17	 070220	 051042	 070220

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:44:20 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 30340

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF/S.D./J.F. 07/02/12

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 07/02/20 (4 16 R.15)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 40.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

630397 ✓

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit \* Total : 192.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

630380 ✓  
B20390

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

B28432 ✓

CP 04/02/21 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 1/22/2007 7:44:20 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 30340

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 192.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

B26485 ✓

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4166 f(s)/Unit Total : 6.6656 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050

Rubber Cushion

B18806 1X ✓ B26472 95X ✓ <sup>Morceaux</sup>

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 192.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

M103585 ✓

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 192.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M101124 (165X) ✓ M102280 (27X) ✓

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 384.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M101938 (204) ✓ M103338 (180X) ✓

204/02/21  
(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/02/22

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/22/2007 7:44:21 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (19"X24")

Job Number: 30340

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 192.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M19185 (71)

M103349 (16)

185X  
C 7/2/21 (16)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206 559-913

Location:

DNAF

C 7/2/21 (16)

C 7/2/21 (16)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

C 7/2/21 (16)

Job Completion



U 07-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	30340
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2432
<b>Inspection Dwg:</b> D2432 <b>Rev:</b> F3		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010 .06	✓			
B	5.500	+/-0.030 5.500	✓			
C	0.200	+/-0.030 .192	✓			
D	0.25 x 45°	+/-0.030 .25 x 45°	✓			
E	R0.250	+/-0.030 R.250	✓			
F	0.250	+/-0.010 .250	✓			
G	0.625	+/-0.030 .625	✓			
H	0.375	+/-0.010 .385	✓			
I	0.950	+0.030/0.010 .950	✓			
J	19.000	+/-0.030 19.000	✓			
K	3.14	+/-0.030 3.14	✓			
L	3.28	+/-0.030 3.278	✓			
M	Ø0.260	+0.005/-0.000 .260	✓			
N	Ø0.93	+/-0.030 .93	✓			
O	0.30	+0.030/-0.000 .310	✓			
P	23.750	+/-0.030 23.750	✓			
Q	7.375	+/-0.030 7.380	✓			
R	4.250	+/-0.010 4.250	✓			
S	2.000	+/-0.030 2.000	✓			
T	9.000	+/-0.010 9.000	✓			
U	9.000	+/-0.010 9.000	✓			
V	0.375	+/-0.010 .375	✓			

<b>Measured by:</b> MS	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/02/13	<b>Date:</b> 07/02/14	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue      P/O K10008/D206-559-015	KJ/RF [Signature]	[Signature]



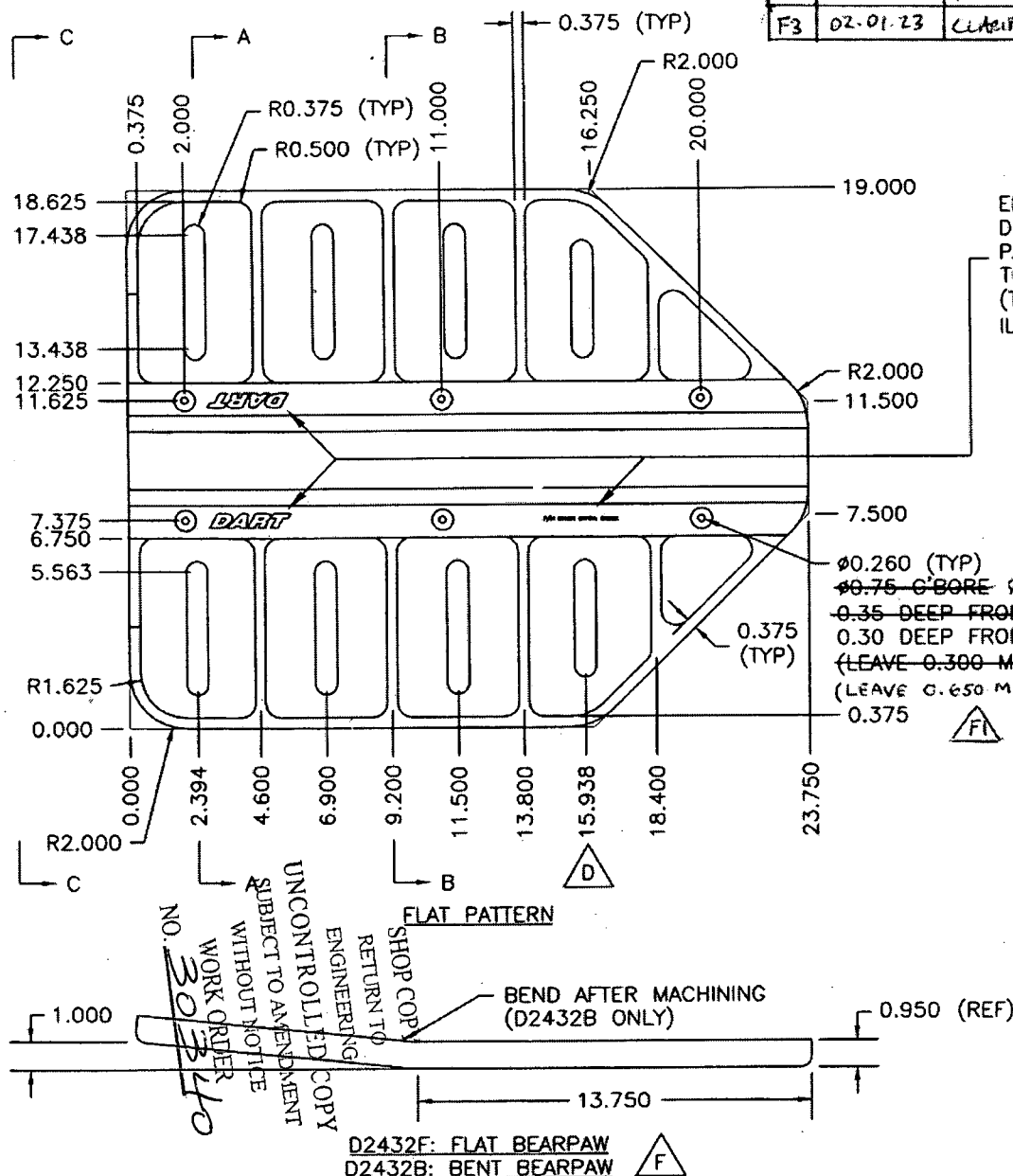
DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
MM	MM	D2432
DATE	TITLE	SHEET 1 OF 2
98.05.12	BEARPAW	SCALE
		1:6

RELEASED  
98.06.17 KE

A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

F1	99.03.03	ADD DEC 9143
F2	01.03.28	<del>Ø0.93 WAS Ø0.75</del> RF
F3	02.01.23	CLARIFY BORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

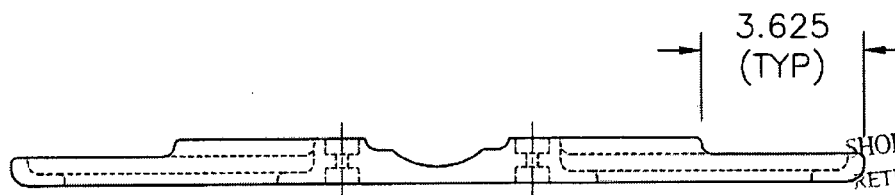
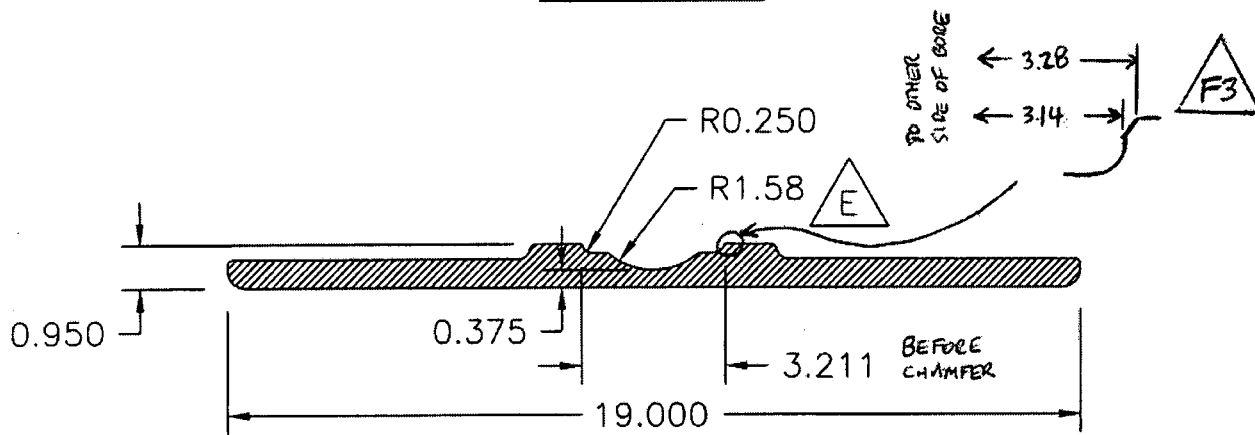
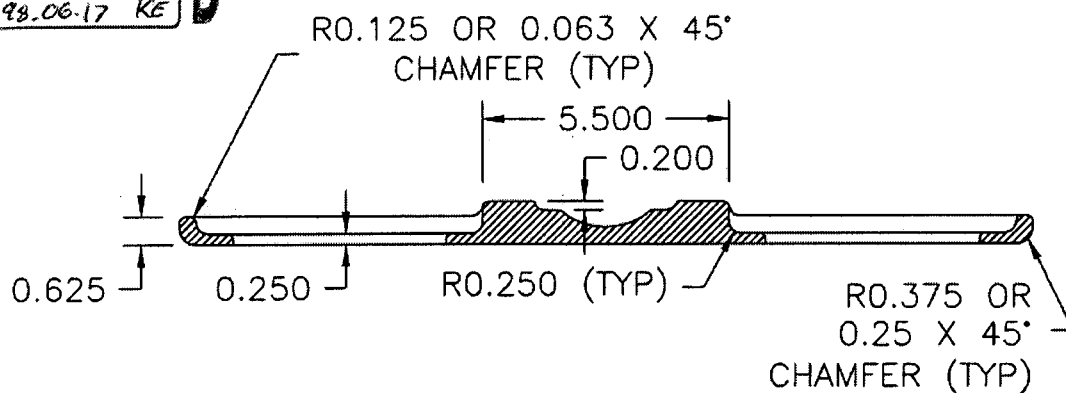


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED  
98.06.17 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30340

Customer : CC-DAR01 Dart Aerospace Ltd.  
Job Number : 36674  
Estimate Number : 10804  
P.O. Number : *N/A*  
This Issue : 09/01/2008 S.O. No. : *N/A*  
Prsht Rev. : *NC*  
First Issue : *N/A* Type : MACHINED PARTS  
Previous Run : 00015

Drawing Name : D206-559

Part Number : Z\_CUSTOM  
Drawing Number : ECN1101  
Project Number : *N/A*  
Drawing Revision : *N/A*  
Material : *N/A*  
Due Date : 16/01/2008

Qty: 1 Um: Each

Written By :                       
Checked & Approved By :                       
Comment :                     

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
REMOVE FROM STOCK:

D206-559-011 *B34288 (10x) B30377(x2) B30800(x1) B32977(x5)*  
D206-559-013 *B32728 9x B30340 (2x)*  
D206-559-021 *B28342 (x4)*  
D206-559-023 *B25291(x3) B34856(x5)*  
D206-559-025 *B28731 (x4)*

ADD NEW PAPERWORK JCAB STC: STC-90-TYO  
PER ECN 1101

RETURN TO STK

*8/1/10 SD 45x AS*

2.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*20810/11*

Job Completion



*12 28-a.11*